

PrimeBore Product Overview

PrimeBore VERSATILE FINE BORING

Advancing versatile technology.

With over 30 years of development, the Wohlhaupter® PrimeBore boring head offers versatility and precision. The PrimeBore head can bore multiple hole sizes ranging from 0.118" - 8.189" (3.00 mm - 208.00 mm) with our broad range of compatible boring bars.

Complete your boring job with *technology that continues to advance.*

- Diameter range: 0.118" - 8.189" (3.00 mm - 208.00 mm)
- Ease the stress of working on different day-to-day projects with boring kits
- 0.0001" (0.002 mm) adjust on diameter
- Economical precision and versatility
- Max spindle speed: 12,000 RPM
- Coolant through

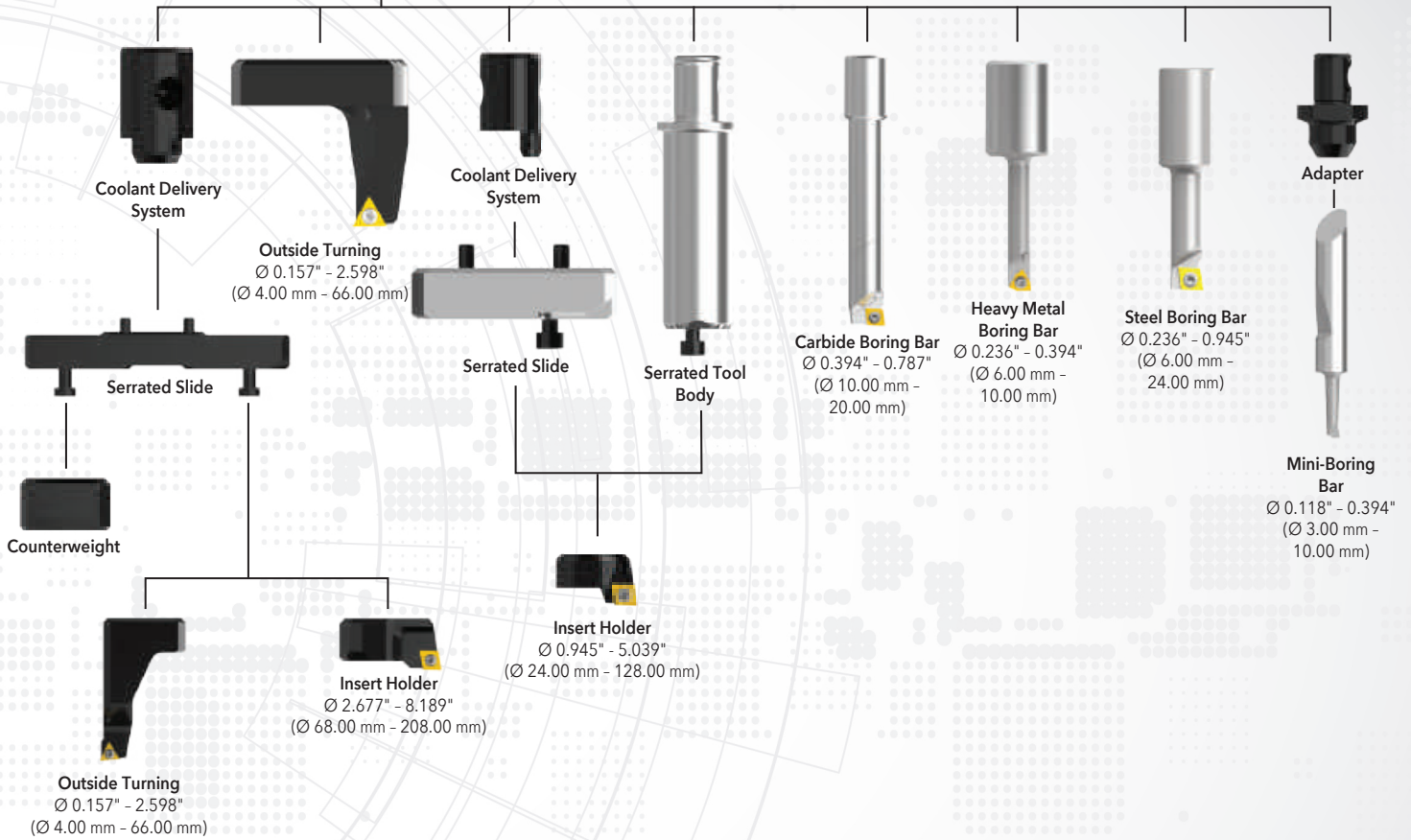


IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: 7611 | email: appeng@alliedmachine.com

PRIME BORE



PrimeBore Head



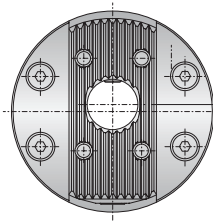
OPERATION **VERSATILITY**

from **0.118"** to **8.189"** (3.00 mm to 208.00 mm)
plus outside turning

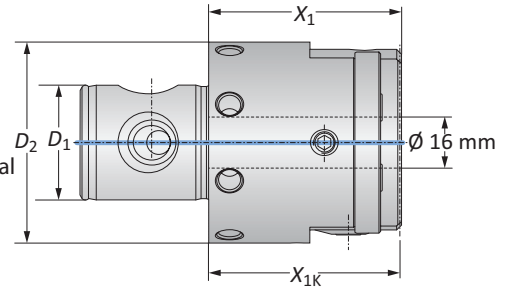


Boring Heads

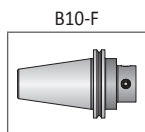
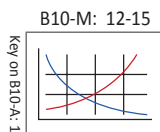
Diameter Range: 0.118" - 8.189" (3.00 mm - 208.00 mm)



+4.5
-0.1
Fine Radial Stroke



	MVS Connection		Boring Head		Weight	Part No.
	D_2 D_1	Boring Range	X_1	X_{1K}		
i	63 - 36	0.118 - 8.189	2.362	2.343	2.866 (lbs)	451001
m	63 - 36	3.00 - 208.00	60.00	59.50	1.30 (kg)	450001

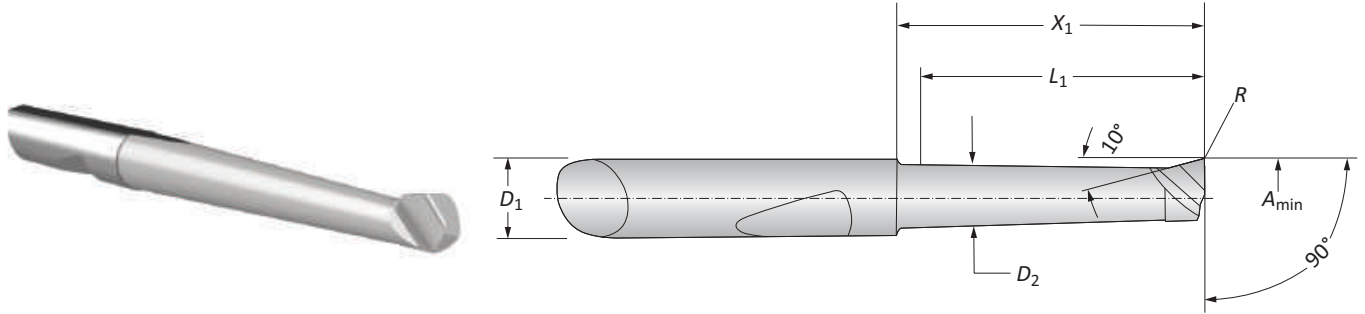


i = Imperial (in)
m = Metric (mm)

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Mini Boring Bars

WHC05 | WHW04 | WBN150 | Diameter Range: 0.118" - 0.394" (3.00 mm - 10.00 mm)



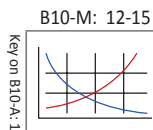
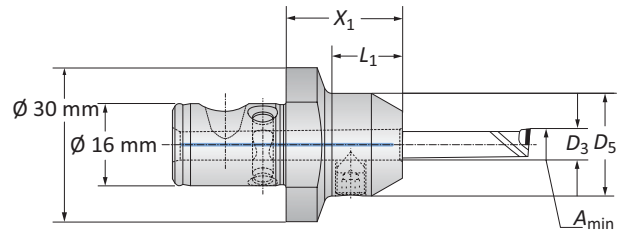
Mini Boring Bars

Boring Range	Boring Bar					Part No.			
	A_{min}	D_1	D_2	X_1	L_1	R	Coated Carbide	Uncoated Carbide	CBN
i	0.118	0.236	0.102	0.452	0.393	0.003	081306WHC05	-	081322WBN150
	0.118	0.236	0.102	0.649	0.590	0.003	081307WHC05	081307WHW04	-
	0.157	0.236	0.141	0.472	0.393	0.007	081308WHC05	-	081317WBN150
	0.157	0.236	0.141	0.669	0.590	0.007	081309WHC05	-	081341WBN150
	0.157	0.236	0.141	0.866	0.787	0.007	081310WHC05	081310WHW04	-
	0.196	0.236	0.181	0.472	0.393	0.007	081311WHC05	-	081318WBN150
	0.196	0.236	0.181	0.866	0.787	0.007	081312WHC05	-	081319WBN150
	0.196	0.236	0.181	1.259	1.181	0.007	081313WHC05	081313WHW04	-
	0.236	0.236	0.220	0.866	0.787	0.007	081314WHC05	-	081320WBN150
	0.236	0.236	0.220	1.259	1.181	0.007	081315WHC05	-	081321WBN150
	0.236	0.236	0.220	1.653	1.574	0.007	081316WHC05	081316WHW04	-
	0.315	0.315	0.229	0.984	0.905	0.007	081323WHC05	-	-
	0.315	0.315	0.229	1.968	1.889	0.007	081324WHC05	-	-
	m	3.00	6.00	2.60	11.50	10.00	0.10	081306WHC05	-
3.00		6.00	2.60	16.50	15.00	0.10	081307WHC05	081307WHW04	-
4.00		6.00	3.60	12.00	10.00	0.20	081308WHC05	-	081317WBN150
4.00		6.00	3.60	17.00	15.00	0.20	081309WHC05	-	081341WBN150
4.00		6.00	3.60	22.00	20.00	0.20	081310WHC05	081310WHW04	-
5.00		6.00	4.60	12.00	10.00	0.20	081311WHC05	-	081318WBN150
5.00		6.00	4.60	22.00	20.00	0.20	081312WHC05	-	081319WBN150
5.00		6.00	4.60	32.00	30.00	0.20	081313WHC05	081313WHW04	-
6.00		6.00	5.60	22.00	20.00	0.20	081314WHC05	-	081320WBN150
6.00		6.00	5.60	32.00	30.00	0.20	081315WHC05	-	081321WBN150
6.00		6.00	5.60	42.00	40.00	0.20	081316WHC05	081316WHW04	-
8.00		8.00	7.60	25.00	23.00	0.20	081323WHC05	-	-
8.00		8.00	7.60	50.00	48.00	0.20	081324WHC05	-	-



Adapters

	Adapter				Part No.
	D_3	D_5	X_1	L_1	
m	6.00	20.00	22.50	14.00	319010
	8.00	22.00	22.50	14.00	236071



i = Imperial (in)
m = Metric (mm)

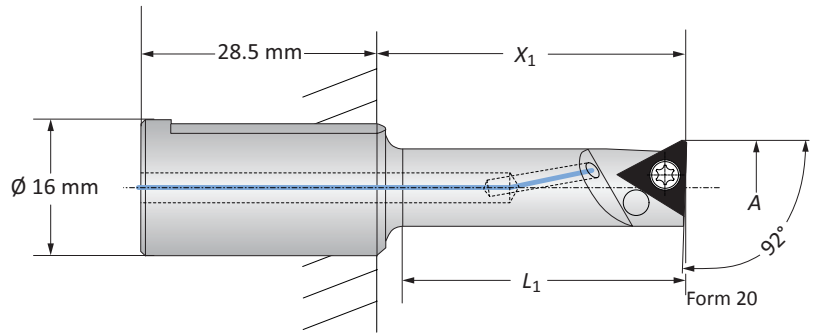
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Boring Bars

Steel | Heavy Metal



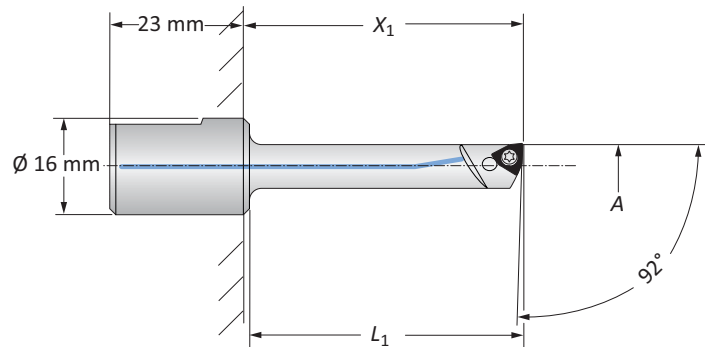
Form 101



Steel Boring Bars | Diameter Range: 0.236" - 0.945" (6.00 mm - 24.00 mm)

	Boring Range		Boring Bar		Weight	Insert Form	Part No.
	A	X ₁	L ₁				
i	0.236 - 0.394	0.866 - 1.260	0.787		0.090 (lbs)	211*	450026
	0.394 - 0.630	1.378 - 1.772	1.299		0.130 (lbs)	101	450027
	0.394 - 0.630	1.378 - 1.772	1.299		0.130 (lbs)	20*	450038
	0.630 - 0.945	2.362 - 2.756	2.283		0.220 (lbs)	101	450028
	0.630 - 0.945	2.362 - 2.756	2.283		0.220 (lbs)	20*	450039
m	6.00 - 10.00	22.00 - 32.00	20.00		0.04 (kg)	211*	450026
	10.00 - 16.00	35.00 - 45.00	33.00		0.06 (kg)	101	450027
	10.00 - 16.00	35.00 - 45.00	33.00		0.06 (kg)	20*	450038
	16.00 - 24.00	60.00 - 70.00	58.00		0.10 (kg)	101	450028
	16.00 - 24.00	60.00 - 70.00	58.00		0.10 (kg)	20*	450039

*Not suitable for indexable inserts with a radius of 0.031" (0.80 mm)



Heavy Metal Boring Bars | Diameter Range: 0.236" - 0.394" (6.00 mm - 10.00 mm)

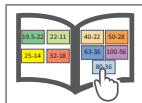
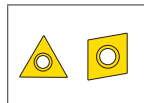
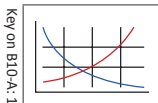
	Boring Range		Boring Bar		Weight	Insert Form	Part No.
	A	X ₁	L ₁				
i	0.236 - 0.315	1.260	1.142		0.176 (lbs)	211*	081055
	0.315 - 0.394	1.772	1.654		0.198 (lbs)	211*	218072
m	6.00 - 8.00	32.00	29.00		0.08 (kg)	211*	081055
	8.00 - 10.00	45.00	42.00		0.09 (kg)	211*	218072

*Not suitable for indexable inserts with a radius of 0.031" (0.80 mm)

B10-M: 12-15

B10-H

B10: vi-vii



i = Imperial (in)
m = Metric (mm)

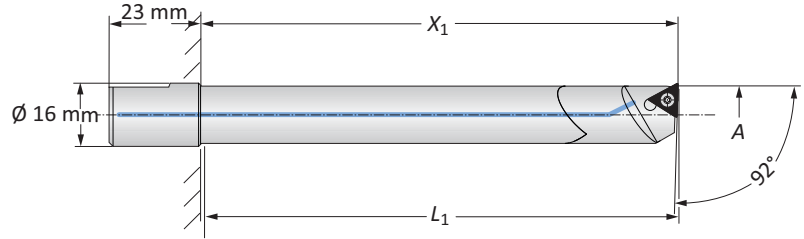
Inserts sold separately

Boring Bars

Carbide | Diameter Range: 0.393" - 0.787" (10.00 mm - 20.00 mm)



Form 101

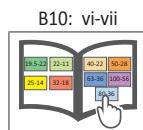
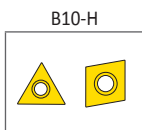
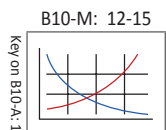


Form 20

Carbide Boring Bars

	Boring Range		Boring Bar		Weight	Insert Form	Part No.	Insert Form	Part No.
	A	X ₁	L ₁						
i	0.394 - 0.472	2.165	2.047		0.154 (lbs)	101	218042	20*	218037
	0.394 - 0.472	2.953	2.835		0.198 (lbs)	101	218032	20*	218029
	0.472 - 0.551	2.756	2.638		0.220 (lbs)	101	218043	20*	218038
	0.472 - 0.551	3.543	3.425		0.331 (lbs)	101	218033	20*	218030
	0.551 - 0.630	2.953	2.835		0.353 (lbs)	101	218044	20*	218039
	0.551 - 0.630	3.937	3.819		0.441 (lbs)	101	218045	20*	218040
	0.630 - 0.787	3.543	3.425		0.573 (lbs)	101	218046	20*	218041
	0.630 - 0.787	4.724	4.606		0.728 (lbs)	101	218034	20*	218031
m	10.00 - 12.00	55.00	52.00		0.07 (kg)	101	218042	20*	218037
	10.00 - 12.00	75.00	72.00		0.09 (kg)	101	218032	20*	218029
	12.00 - 14.00	70.00	67.00		0.10 (kg)	101	218043	20*	218038
	12.00 - 14.00	90.00	87.00		0.15 (kg)	101	218033	20*	218030
	14.00 - 16.00	75.00	72.00		0.16 (kg)	101	218044	20*	218039
	14.00 - 16.00	100.00	97.00		0.20 (kg)	101	218045	20*	218040
	16.00 - 20.00	90.00	87.00		0.26 (kg)	101	218046	20*	218041
	16.00 - 20.00	120.00	117.00		0.33 (kg)	101	218034	20*	218031

*Not suitable for indexable inserts with a radius of 0.031" (0.80 mm)

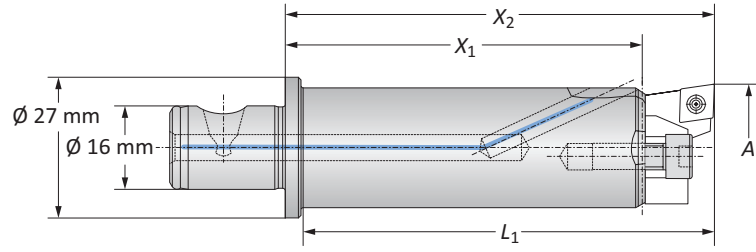


i = Imperial (in)
 m = Metric (mm)
 Inserts sold separately

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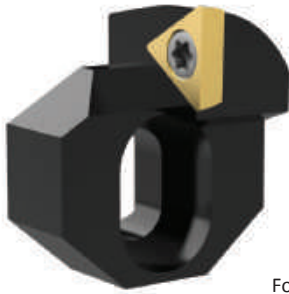
Serrated Tool Bodies | Insert Holders

Diameter Range: 0.945" - 2.559" (24.00 mm - 65.00 mm)

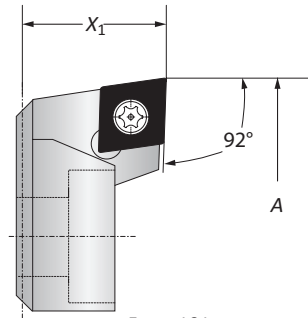


Serrated Tool Bodies

	Boring Range	Serrated Tool Body			Weight	Part No.
	A	X ₁	X ₂	L ₁		
i	0.945 - 2.559	2.667	3.228	3.110	0.441 (lbs)	450021
m	24.00 - 65.00	68.00	82.00	79.00	0.20 (kg)	450021



Form 20



Form 101

Insert Holders

	Boring Range	Insert Holder	Weight	Insert Form	Part No.
	A	X ₁			
i	0.945 - 1.575	0.551	0.044 (lbs)	101	450022
	0.945 - 1.575	0.551	0.044 (lbs)	20*	450040
	1.575 - 2.559	0.551	0.066 (lbs)	101	450023
	1.575 - 2.559	0.551	0.066 (lbs)	20*	450041
m	24.00 - 40.00	14.00	0.02 (kg)	101	450022
	24.00 - 40.00	14.00	0.02 (kg)	20*	450040
	40.00 - 65.00	14.00	0.03 (kg)	101	450023
	40.00 - 65.00	14.00	0.03 (kg)	20*	450041

*Not suitable for indexable inserts with a radius of 0.031" (0.80 mm)

B10-M: 12-15

B10-A: 47

B10-H

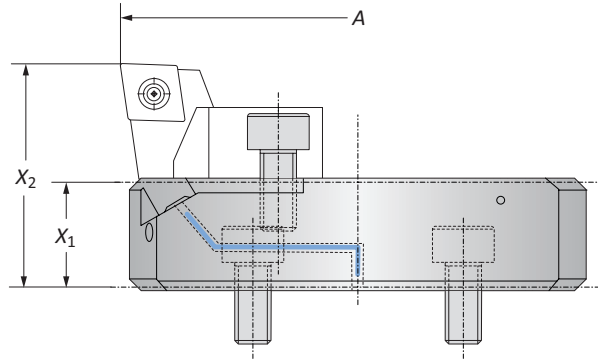
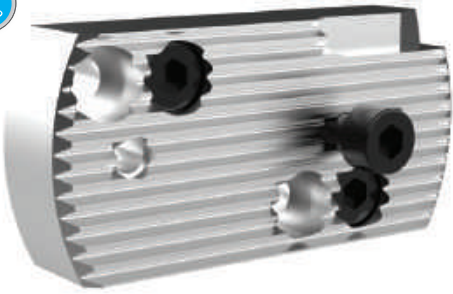
B10: vi-vii

Key on B10-A: 1

i = Imperial (in)
m = Metric (mm)
 Inserts sold separately

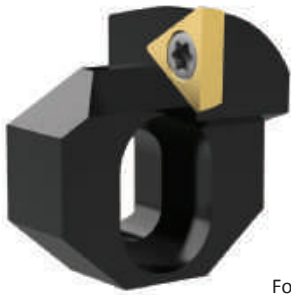
Serrated Slides | Insert Holders

Diameter Range: 2.559" - 5.039" (65.00 mm - 128.00 mm)

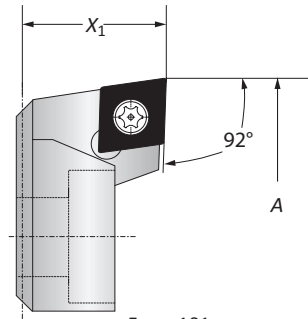


Serrated Slides

	Boring Range	Serrated Slide		Weight	Part No.
	A	X ₁	X ₂		
i	2.559 - 5.039	0.571	1.161	0.176 (lbs)	450024
m	65.00 - 128.00	14.50	29.50	0.08 (kg)	450024



Form 20



Form 101

Insert Holders

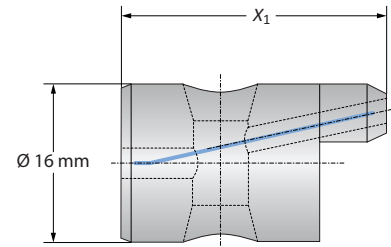
	Boring Range	Insert Holder	Weight	Insert Form	Part No.
	A	X ₁			
i	2.559 - 5.039	0.551	0.066 (lbs)	101	450023
	2.559 - 5.039	0.551	0.066 (lbs)	20*	450041
m	65.00 - 128.00	14.00	0.03 (kg)	101	450023
	65.00 - 128.00	14.00	0.03 (kg)	20*	450041

*Not suitable for indexable inserts with a radius of 0.031" (0.80 mm)

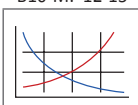


Alu-Line Coolant Delivery Sections

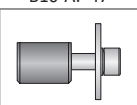
	Coolant Delivery Section		Part No.
	X ₁	Weight	
m	26.75	0.01 (kg)	450125



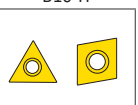
B10-M: 12-15




B10-A: 47



B10-H



B10: vi-vii



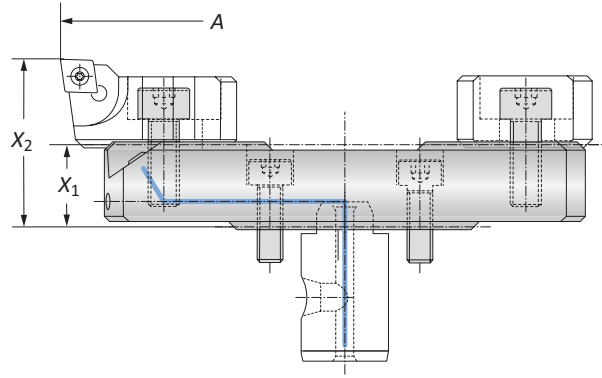
Key on B10-A: 1

i = Imperial (in)
m = Metric (mm)
 Inserts sold separately

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Alu-Line Serrated Slides | Insert Holders

Diameter Range: 2.667" - 8.189" (68.00 mm - 208.00 mm)



Alu-Line Serrated Slides

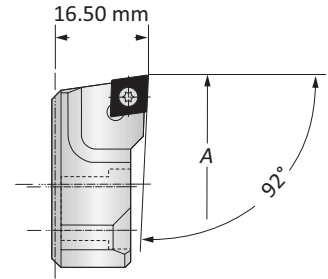
	Boring Range		Serrated Slide		Weight	Part No.
	A		X ₁	X ₂		
i	2.667 - 3.780		0.630	1.280	0.220 (lbs)	501054
	3.780 - 4.882		0.630	1.280	0.220 (lbs)	501055
	4.882 - 5.984		0.630	1.280	0.441 (lbs)	501056
	5.984 - 7.087		0.866	1.516	0.551 (lbs)	501058
	7.087 - 8.189		0.866	1.516	0.661 (lbs)	501059
m	68.00 - 96.00		16.00	32.50	0.10 (kg)	501054
	96.00 - 124.00		16.00	32.50	0.10 (kg)	501055
	124.00 - 152.00		16.00	32.50	0.20 (kg)	501056
	152.00 - 180.00		22.00	38.50	0.25 (kg)	501058
	180.00 - 208.00		22.00	38.50	0.30 (kg)	501059

Insert Holders

	Boring Range		Insert Form	Part No.
	A	Weight		
i	2.677 - 8.189	0.110 (lbs)	101	502064
	2.677 - 8.189	0.110 (lbs)	20	502069
m	68.00 - 208.00	0.05 (kg)	101	502064
	68.00 - 208.00	0.05 (kg)	20	502069



Form 20

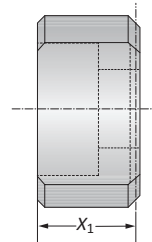


Form 101

NOTE: Other insert holders available upon request

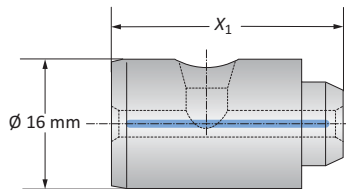
Counterweights

	Counterweights		Part No.
	X ₁	Weight	
i	0.528	0.110 (lbs)	502165
m	13.40	0.05 (kg)	502165



Alu-Line Coolant Delivery Sections

	Coolant Delivery Section		Part No.
	X ₁	Weight	
i	1.004	0.022 (lbs)	450137
m	25.50	0.01 (kg)	450137



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B10-A: 47

B10-H

B10: vi-vii

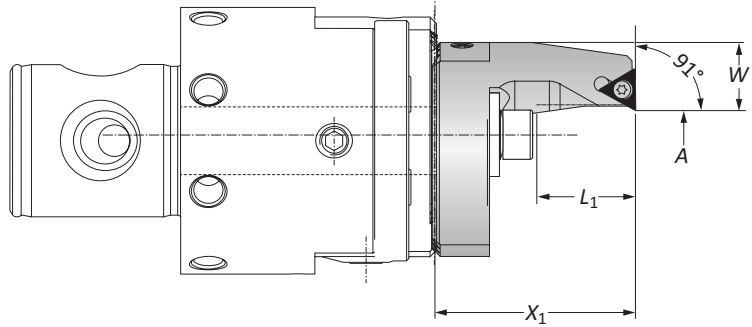
Key on B10-A: 1

i = Imperial (in)
m = Metric (mm)

Inserts sold separately

Outside Turning Insert Holders for Boring Heads

Diameter Range: 0.157" - 2.598" (4.00 mm - 66.00 mm)

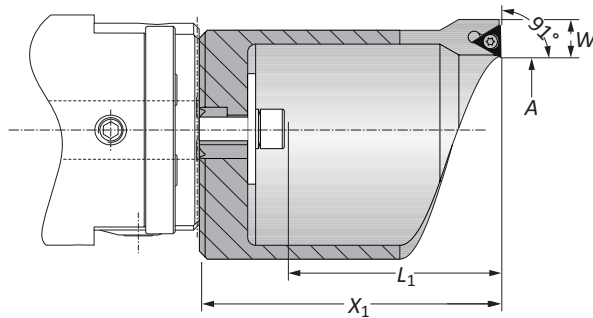


Type A Insert Holders | Diameter Range: 0.157" - 1.181" (4.00 mm - 30.00 mm)

	Boring Range		Insert Holder			Weight	Type	Insert Form	Part No.
	A	X ₁	L ₁	W					
i	0.157 - 0.689	1.594	0.787	0.653	0.220 (lbs)	A	20*	236081	
	0.650 - 1.181	1.988	1.181	0.437	0.220 (lbs)	A	20*	236082	
m	4.00 - 17.50	40.50	20.00	16.60	0.10 (kg)	A	20*	236081	
	16.50 - 30.00	50.50	30.00	11.10	0.10 (kg)	A	20*	236082	

NOTE: Clockwise and neutral execution

*Not suitable for indexable inserts with a radius of 0.031" (0.80 mm)



Type B Insert Holders | Diameter Range: 1.142" - 2.598" (29.00 mm - 66.00 mm)

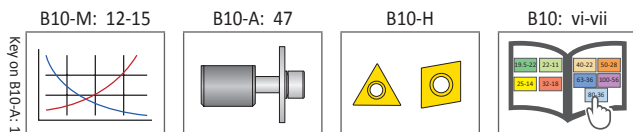
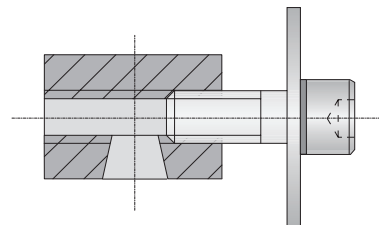
	Boring Range		Insert Holder			Weight	Type	Insert Form	Part No.
	A	X ₁	L ₁	W					
i	1.142 - 1.732	2.952	2.126	0.377	0.661 (lbs)	B	20*	236083	
	1.693 - 2.598	3.956	3.110	0.377	0.882 (lbs)	B	20*	236084	
m	29.00 - 44.00	75.50	54.00	9.60	0.30 (kg)	B	20*	236083	
	43.00 - 66.00	100.50	79.00	9.60	0.40 (kg)	B	20*	236084	

NOTE: Clockwise and neutral execution

*Not suitable for indexable inserts with a radius of 0.031" (0.80 mm)

Clamping Pieces for Outside Turning Insert Holders

	Insert Holder Type	Boring Range	Service Key	Complete Part No.
m	A	4.00 - 30.00	s5	236088
	B	29.00 - 66.00	s5	236089

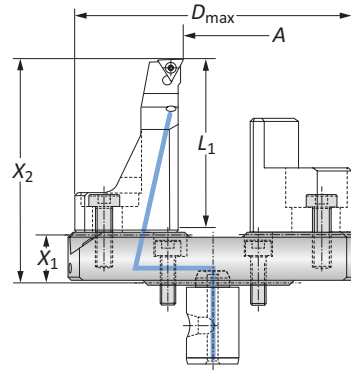


i = Imperial (in)
m = Metric (mm)
Inserts sold separately

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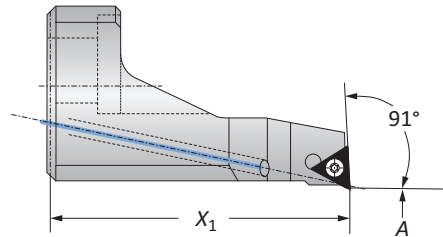
Outside Turning Serrated Slides | Insert Holders

Diameter Range: 0.078" - 4.488" (2.00 mm - 114.00 mm)



Outside Turning Serrated Slides

	Boring Range		Serrated Slide			Weight	Part No.
	A	X ₁	X ₂	L ₁	D _{max}		
i	0.078 - 1.181	0.630	2.874	2.165	3.396	0.771 (lbs)	501064
	1.181 - 2.283	0.630	2.874	2.165	5.078	0.970 (lbs)	501065
	2.283 - 3.386	0.866	3.110	2.165	6.181	1.322 (lbs)	501066
	3.386 - 4.488	0.866	3.110	2.165	7.283	1.609 (lbs)	501067
m	2.00 - 30.00	16.00	73.00	55.00	101.00	0.35 (kg)	501064
	30.00 - 58.00	16.00	73.00	55.00	129.00	0.44 (kg)	501065
	58.00 - 86.00	22.00	79.00	55.00	157.00	0.60 (kg)	501066
	86.00 - 114.00	22.00	79.00	55.00	185.00	0.73 (kg)	501067



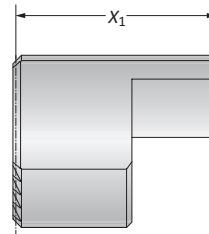
Insert Holders

	Outside Turning Range		Insert Holder		Weight	Insert Form	Part No.
	A	X ₁	X ₁	Weight			
i	0.079 - 4.488		2.244		0.331 (lbs)	20	502082
m	2.00 - 114.00		57.00		0.15 (kg)	20	502082

NOTE: clockwise and neutral execution

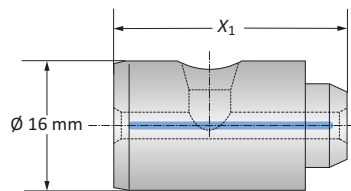
Counterweights

	Counterweight		Part No.
	X ₁	Weight	
i	1.486	0.350 (lbs)	502183
m	37.75	0.16 (kg)	502183



Coolant Delivery Sections

	Coolant Delivery Section		Part No.
	X ₁	Weight	
i	1.004	0.022 (lbs)	450137
m	25.50	0.01 (kg)	450137



B10-M: 12-15

B10-A: 47

B10-H

B10: vi-vii

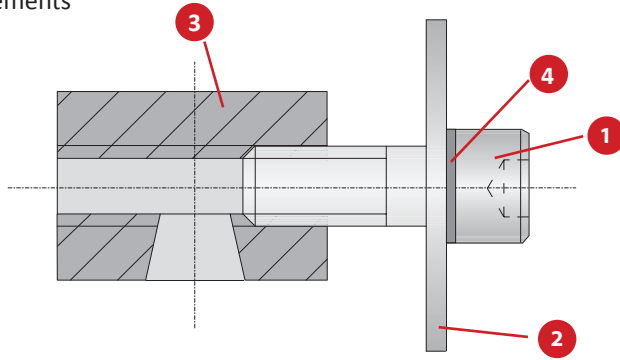
Key on B10-A: 1

i = Imperial (in)
m = Metric (mm)

Inserts sold separately

Accessories

Clamping Elements

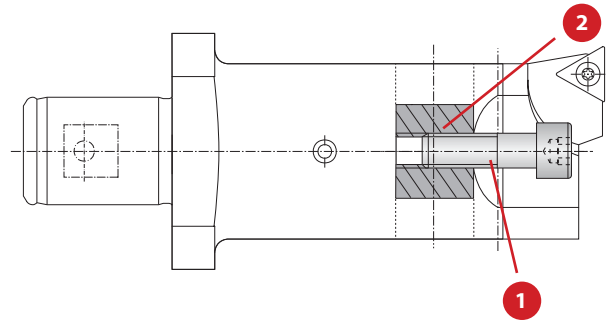


Clamping Elements for Insert Holders

	1	2	3	4		
Boring Range	Cap Screw	Hex Size	Washer	Clamping Nut	Locking Washer	Complete Part No.
m 4.00 - 30.00	070153	s5	315155	236120	215254	236088
29.00 - 66.00	070153	s5	315156	236120	215254	236089

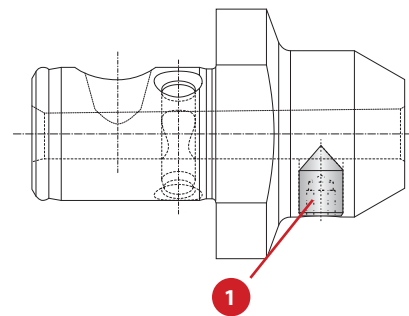
Clamping Elements for Serrated Tool Body

1	2
Cap Screw	Clamping Piece
027154	145184



Thread Pin

1
Service Key
S3 / A
Part No.
415244

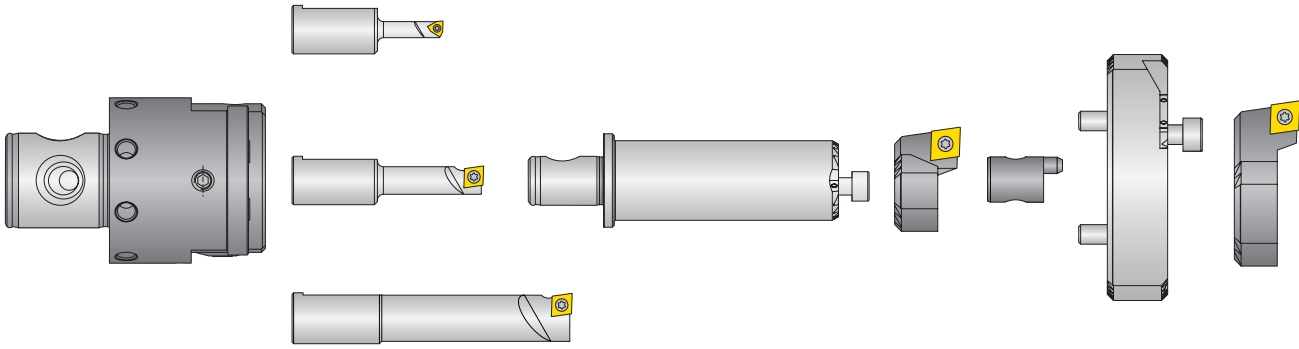


i = Imperial (in)
m = Metric (mm)

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Kit Components

Form 101 | Diameter Range: 0.236" - 5.039" (6.00 mm - 128.00 mm)



Diameter Range: 0.236" - 5.039" (6.00 mm - 128.00 mm)

Kit Components									
Boring Head	Boring Bars		Insert Holders		Serrated Tool Body	Serrated Slide	Coolant Delivery Section	Service Keys	Kit No.
	Boring Range	Part No.	Boring Range	Part No.					
i	0.236 - 0.394	450026 (Form 211)	0.945 - 1.575	450022	450021	450024	450125	003195 (s4) 515451 (T6) 515452 (T8)	104088
	0.394 - 0.630	450027 (Form 101)	1.575 - 2.559	450023					
	0.630 - 0.945	450028 (Form 101)							
m	6.00 - 10.00	450026 (Form 211)	24.00 - 40.00	450022	450021	450024	450125	003195 (s4) 515451 (T6) 515452 (T8)	103088
	10.00 - 16.00	450027 (Form 101)	40.00 - 65.00	450023					
	16.00 - 24.00	450028 (Form 101)							

NOTE: Inserts sold separately

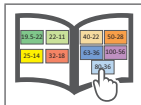
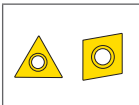
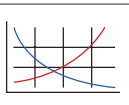


B10-M: 12-15

B10-H

B10: vi-vii

Key on B10-A: 1



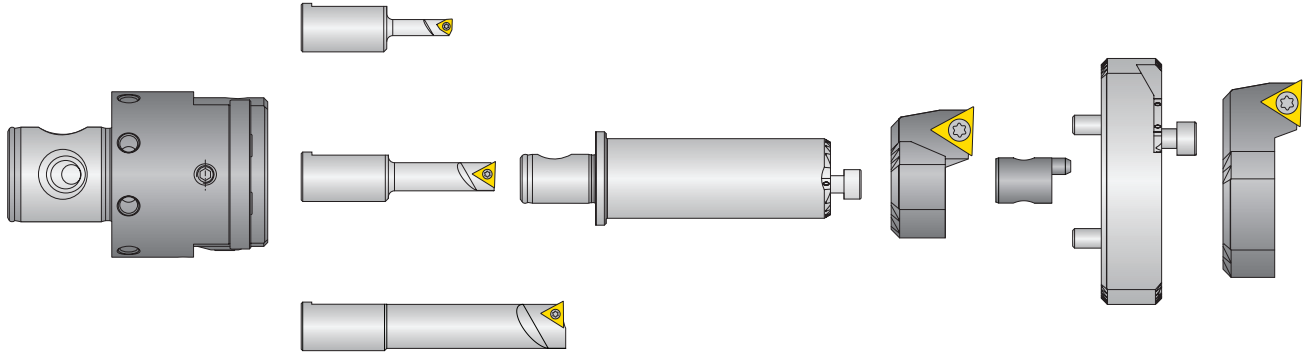
i = Imperial (in)
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: 7611 | email: appeng@alliedmachine.com

Kit Components

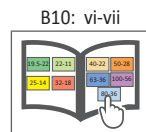
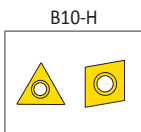
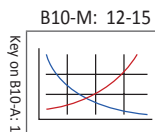
Form 20 | Diameter Range: 0.236" - 5.039" (6.00 mm - 128.00 mm)



Diameter Range: 0.236" - 5.039" (6.00 mm - 128.00 mm)

Kit Components									
Boring Head	Boring Bars		Insert Holders		Serrated Tool Body	Serrated Slide	Coolant Delivery Section	Service Keys	Kit No.
	Boring Range	Part No.	Boring Range	Part No.					
i	0.236 - 0.394	450026 (Form 211)	0.945 - 1.575	450040	450021	450024	450125	003195 (s4) 515451 (T6) 515453 (T7)	104089
	0.394 - 0.630	450038 (Form 20)	1.575 - 2.559	450041					
	0.630 - 0.945	450039 (Form 20)							
m	6.00 - 10.00	450026 (Form 211)	24.00 - 40.00	450040	450021	450024	450125	003195 (s4) 515451 (T6) 515453 (T7)	103089
	10.00 - 16.00	450038 (Form 20)	40.00 - 65.00	450041					
	16.00 - 24.00	450039 (Form 20)							

NOTE: Inserts sold separately



i = Imperial (in)
m = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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